

Work Order ID 72811

Monday, August 15, 2011 2:33:57 PM



Page 1

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 8/15/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/08/15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch: 108 331

Cut @ meter

CL 11/08/15

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927

DWG REV:

FOLIO REV:

(Check for crack while loading into the machine.)

2- deburr rough edges

CL 11/08/15 100

issue P/O to meter P/O: 14684

machine as per dwg D2230 REV.G

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 72811

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Page 2

Item ID: D2230-1

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

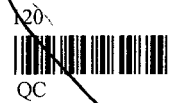
Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp



QC
Quality Control

~~QC2-Inspect parts off machine FAI/FAIB~~

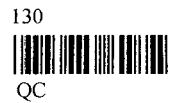
0.00

Memo

0.00

*we'd + inspect for transit damage
attached cnc to w/o*

Run 37 100



QC
Quality Control

~~QC2~~ Inspect parts - second check

0.00

Memo

0.00

8/15/11

*center
H60*



HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

100 BR 11-8-31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 72811

Monday, August 15, 2011 2:33:57 PM



Page 3

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 8/15/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

100 0 11/09/01

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:40
320
8:10

0.00

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

100 X 0 M 11/09/01

100 0 11/09/01



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 72811

Monday, August 15, 2011 2:33:57 PM



Page 4

Item ID: D2230-1

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Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 8/15/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 Packaging | Identify as per dwg & Stock Location: <u>5480</u> Memo | 0.00 0.00 | | | | | | | |
| 190 QC | QC21 - Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

(100x)

8p

11-09-01

11/9/01

mf

11-09-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, August 15, 2011 2:33:55 PM

Page 1

Work Order ID: 72811

Parent Item: D2230-1

Parent Item Name: Lug



Start Date: 8/15/2011

Required Date: 8/26/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ D ☐ 00.11.01 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC ☐

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-------|--|--------------|----|--|--|-----|---|----------|--------|----------|--|--|--|
| D2423 | | Manufactured | No | | | 110 | f | 538.5000 | 0.0683 | 7.189474 | | | |
|-------|--|--------------|----|--|--|-----|---|----------|--------|----------|--|--|--|



Lug Extrusion



CL 11/08/31

Location

Loc Qty

Loc Code

MAT006

538.5

43722

161.5

45800

1

68331

376

7.19

D2230-1P

x100

CL 11/08/31 (100)

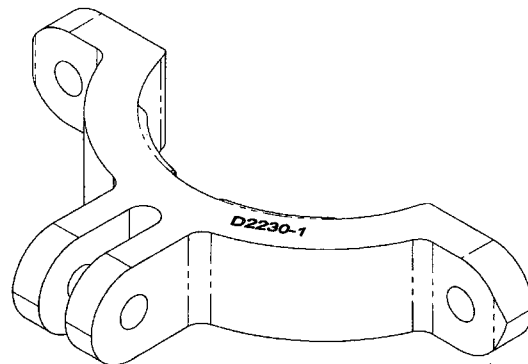
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

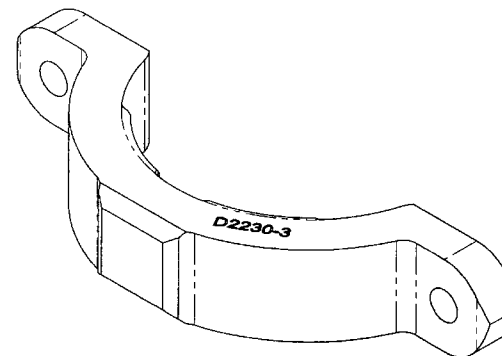
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
09/06/05

CL1108115
W10: 72811



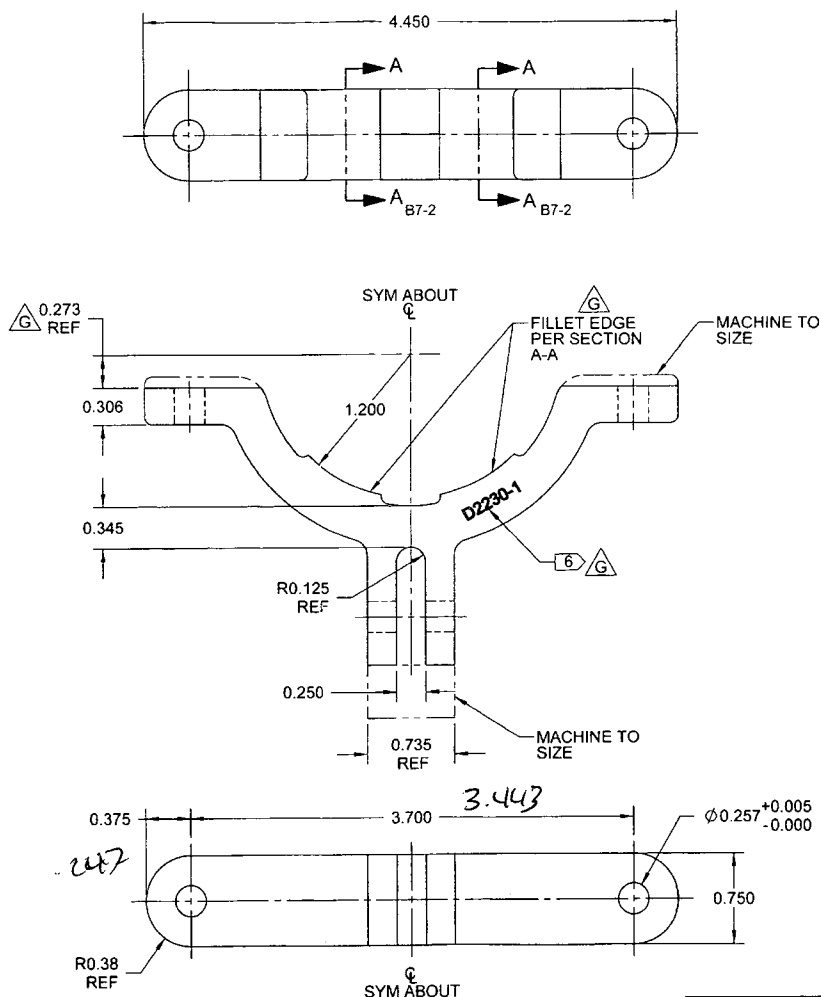
NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

| G | REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION. | AJS | 09.01.16 |
|------------|--|---|--------------|
| F | REDESIGN: R1.200 WAS 1.100 | CP | 99.12.13 |
| E | RE-DESIGN | BW | 95.01.04 |
| D | RE-DESIGN | BW | 95.01.04 |
| C | RE-DESIGN | BW | 94.03.30 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2230 | SHEET 1 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | MOUNTING LUG | NTS |
| DATE | 09.01.16 | <small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

SECTION A-A D4-2
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



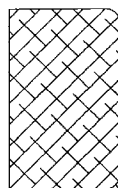
D2230-1 MOUNTING LUG

RELEASED
09/06/25/11

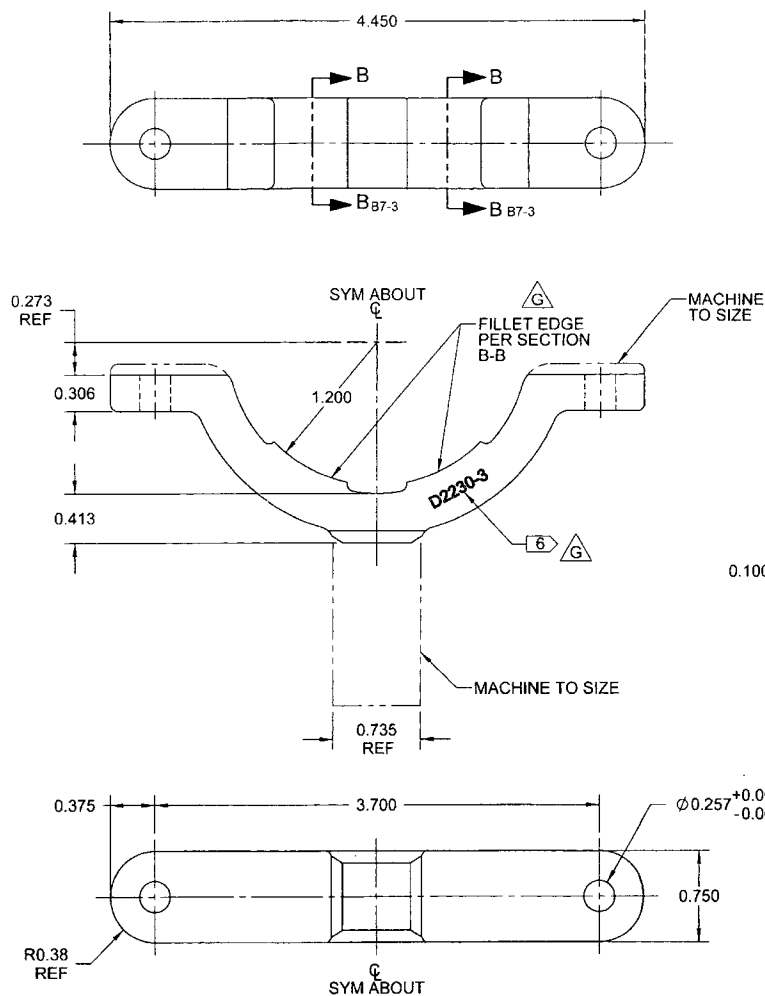
| | | | |
|------------|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2230 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | MOUNTING LUG | NTS |
| DATE | 09.01.16 | <small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

600

SECTION B-B D4-3
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/25

| | | | |
|------------|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2230 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | MOUNTING LUG | NTS |
| DATE | 09.01.16 | COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

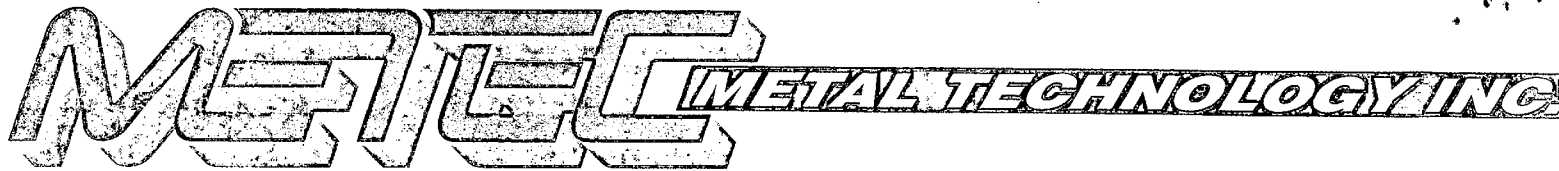


20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18139
Date: Aug 30, 2011
Page: 1

| | |
|--|---|
| Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 | Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 |
| Order No.: 14684 | Sold By: Dewar, Eric |
| Shipped By: your truck | Ship Date: |

| Description | Unit | Ordered quantity | Shipped quantity | Backorder quantity |
|--|------|---------------------------|------------------|--------------------|
| D2230-1 Mounting Lug Material supplied by DART: D2423 B63005 | Each | 100 | 100 | |
| The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted. | | | | |
| Received by _____ | | Thank you for your order! | | |



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

| <u>QUANTITY</u> | <u>PART NUMBER</u> | <u>PART NAME</u> | <u>P.O. NUMBER</u> |
|-----------------|--------------------|------------------|--------------------|
| 100 | D2230-1P | Lug | 14684 |

MATERIAL: supplied by DART D2230 B63005

80062/31

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, August 30, 2011